



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.4003

Job Sheet 176067



Part No: 646.4003

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System Removable Provisions



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 5/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	DAS		
90	Start up Operation	1 Ea	5/9/18	5/9/18	0.00	0.00	Start Up Stores/Pkg-1	6	80	MAY 25 2018
110	Packaging	1 pcs	5/9/18	5/9/18	0.00	0.00	Packaging1-1	80	20	MAY 25 2018
120	QC	1 pcs	5/9/18	5/9/18	0.00	0.00	QC4			SMH
125	DC	1 pcs	5/9/18	5/9/18	0.00	0.00	DC			SMH
130	Packaging	1 pcs	5/9/18	5/9/18	0.00	0.00	Packaging3-1			SMH
140	QC21-FG	1 Ea	5/9/18	5/9/18	0.00	0.00	QC21			SMH

Part Op 125 - Photocopy bluefile & type labels per PPP 646.4003

Descriptions: 130 - Identify and pack for shipping as per PPP 646.4003 Location: _____

DAS
21
9-88

MAY 28 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5055887
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5055890
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5056028
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5066985
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5064604
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5044090
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	505286 5063220
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5031107
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5036176
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5043544
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5038498
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5059863
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5021120
646.3718	Custom Washer 5026885	2 Ea (2 ea)	90-Start up Operation	640-3718
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5037879
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5038811
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5027197
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5065219
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5026060
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5040671

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval _____	
Description Work Order Deviation				Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Pow ☐ Folic ☐ Grai ☐ Wel ☐ Wro ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐			
OTHER : _____				Completed By _____ _____ / Supervisor _____ al Verification _____ Coordinator _____ approval _____ ed Wrong _____ Dimensions _____ nder tolerance _____ rrect _____ t/Missing _____ Part Moved _____ Drawing _____ Finish _____ Misread _____ Turning Sequence			

DART AEROSPACE
 Container No: S074349
 Part: 646.4003
 Job No: 176067
 Serial No/Batch: S074349
 Revision: C1
 Inspector: _____
 Date: 05/25/18

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaero.com

647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5050462
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5065469
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5059378
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5027721
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5048576
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5038733
AN3-4A	Bolt	6 Ea (6 ea)	90-Start up Operation	5060063
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5041106
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	500530
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5056381
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5041156
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5027576
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5041157
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	5133818
MS21042L08	Use Ms21042L08	2 Ea (2 ea)	90-Start up Operation	5044334
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation	5044334
MS21042L3	Nut	SS 53 Ea (53 ea)	90-Start up Operation	5023577
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5054118
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5016502
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5024980
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5050050
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5017320-1
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5049832
MS27039-1-16	Screw	2 Ea (2 ea)	90-Start up Operation	5027545x2
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5050057
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5000680
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5037684
NAS1149F0332P	Washer	120 Ea (120 ea)	90-Start up Operation	5057525
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5050058
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5020604

649.2910 - 5069607x1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	448	0
	600.0990	1	22	0
	600.0991	1	21	0
	600.1012	1	24	0
	600.1013	5	30	0
	646.2910	1	9	0
	646.3001	1	7	0
	646.3110	1	21	0
	646.3301	1	6	0
	646.3510	1	26	0
	646.3511	1	15	0
	646.3610	1	19	0
	646.3711	1	29	0
	646.3712	1	41	0
	646.3716	1	27	0
	646.3718	2	52	0
	646.3811	1	28	0
	646.3910	4	41	0
	646.3911	1	42	0
	646.3912	4	30	0
	646.3913	1	58	0
	646.9410	1	121	0
	647.0112	2	86	0
	647.7703	2	16	0
	650.9201	2	20	0
	AN3-11A	10	235	0
	AN3-12A	2	103	0
	AN3-13A	1	55	0
	AN3-4A	6	496	0
	AN3-5A	2	394	0
	AN3-6A	2	255	0
	AN316C4R	2	44	0
	AN44-5A	2	21	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

AN4C7A	2	89	0
AN665-34R	2	38	0
MS20426AD5-7	2	1,201	0
MS21042-08	2	0	0
MS21042-3	2	254	0
MS21042L3	53	2,433	0
MS21042L4	2	3,235	0
MS24693-C278	5	60	0
MS24694-S51	5	264	0
MS24694-S54	2	115	0
MS24694-S55	3	170	0
MS27039-08-13	2	415	0
MS27039-1-12	6	343	0
MS27039-1-16	2	588	0
MS27039-1-19	22	259	0
MS27039-1-20	2	69	0
MS27039-1-21	4	102	0
NAS1149F0332P	120	3,099	0
NAS1149F0432P	4	2,245	0
NAS1149FN832P	4	3,306	0

Part Specifications

Specifications could not be found.

Plex 4/16/18 2:28 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

REFERENCE ONLY

REFERENCE ONLY

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2. INSTALL F/N 14 WITH F/N 52 & 53.

3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMMASTER-CARR P/N 75935A651.

4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021-200-24216.

5. REUSE FASTENERS FROM F/N 1.

6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7. AT CUSTOMER'S OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

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REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 0219, 0220, 0221 & 0222	01/08/00	P. BRAVO
B	INCORPORATED ECN 0304, 0305 & 0306	11/01/00	P. BRAVO
C	INCORPORATED ECN 0308	01/08/01	P. BRAVO

			2	2	41	601.2829	SCREW	MS20470A554
			2	2	40	601.2831	RIVET	MS20470A55